



专业瓶盖模具 PROFESSIONAL CAP MOULD

广东省佛山市顺德区铭三锋模具有限公司

Mingsanfeng Mould Co., Ltd

Shunde, Foshan city, Guangdong province



广东顺德铭三锋模具有限公司

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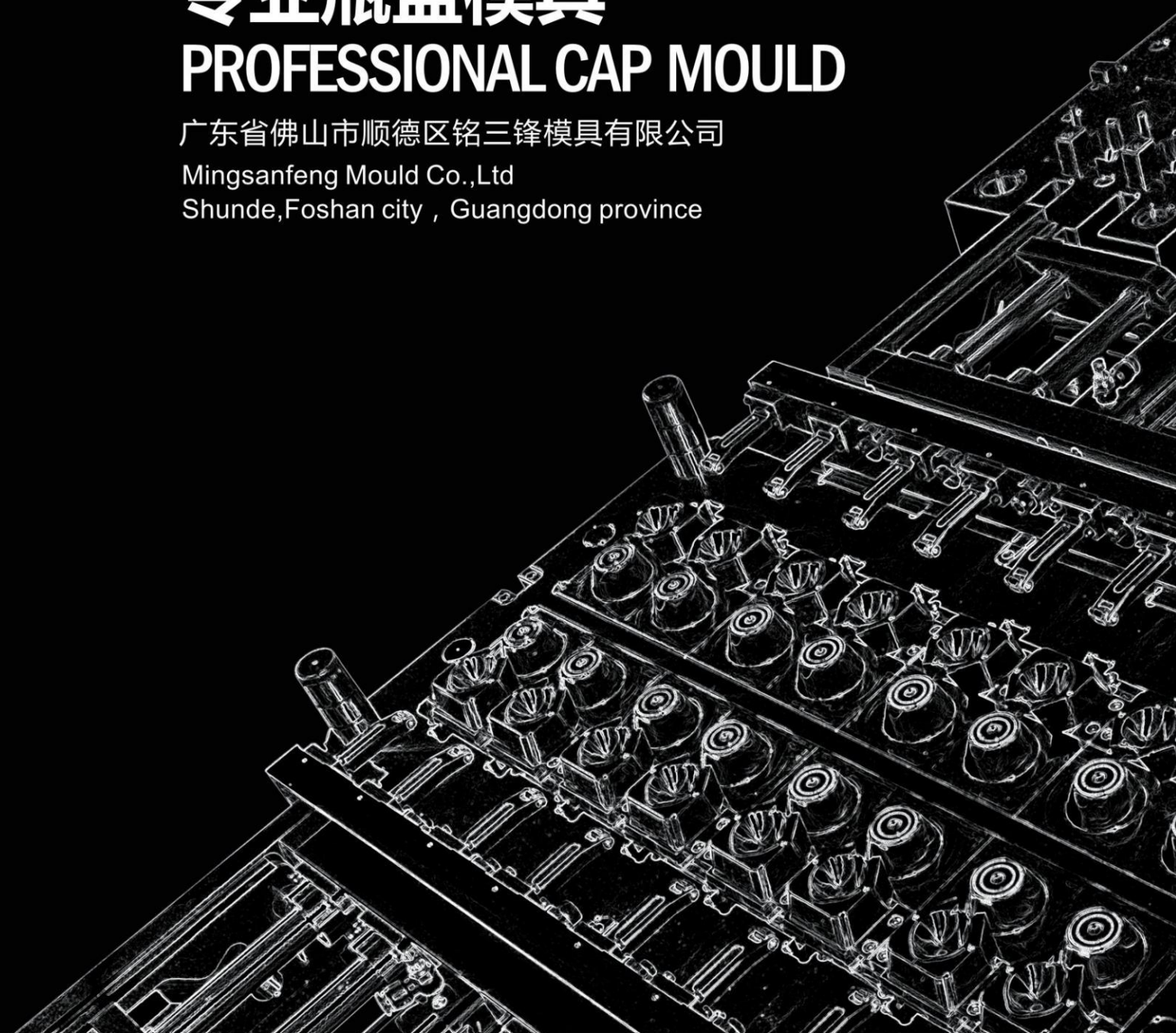
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企业简介

铭三锋模具有限公司坐落于美丽富饶的城市——广东顺德。这里交通十分便捷，距离广州只有二十分钟车程，更素有“广东四小龙”之美誉。

公司成立于1999年6月，专业从事瓶盖模具研发、生产、销售服务于一体的企业，具有丰富研发、生产瓶盖模具经验，引领行业先锋。公司现有在职员工近100人，拥有研发设计工程师约10人，高级模具工程师约20人，高级技工约30人。公司采用现代化管理模式，具备年生产模具产量达300套的能力，年营业额可高达五千万元。

公司一直专注塑料瓶盖模具的研发和生产。公司拥有进口数控加工中心、日本三菱数控设备、日本沙迪克、台湾庆鸿慢走丝线切割、镜面火花机床等国际模具先进生产设备。同时公司采用CAD/CAM/CAE（Pro/E,UG,等）进行电脑辅助设计和加工软件，能独立承接国际高端客户各类高难度、高精度大中小模具和特殊性能注塑制品业务，专业研究开发和生产各类瓶盖产品和各种瓶盖模具的设计与加工。竭诚为广大客户提供“产品开发、模具设计、模具制造、注塑加工、装配生产”一站式服务。

“以科技为动力，打造核心竞争力，引领行业先锋”是铭三锋遵循的企业哲学，我们竭诚期待着与各界朋友一起与时俱进，为谋求共同的发展而努力奋斗。我们有句话：唯有真诚做人，用心做事，才能以品质创品牌。铭三锋人立足顺德，放眼世界，愿与您成为长期的战略伙伴！



Professional Cap Mould Company Profile

Ming San Feng Mould Co., Ltd is located in a beautiful and affluent city-Guangdong Shunde. The transportation infrastructure in this city is very convenient, with only twenty minutes from Guangzhou. It is also well known as one of the “Four Tiger in Guangdong”

Founded in June 1999, the company specialises in the development, production, sales, and service in bottle cap moulding. With the strong experience in R&D and production of bottle cap mould, this makes the company the leader for the industry pioneers.

The company has always been focusing in areas of R&D and production of bottle cap mould. It possesses the imported CNC machining facility, Mitsubishi CNC equipment, Sodick NC and Taiwan Qing Hong slow-feeding wire-cut EDM/Mirror production equipment. It also uses the advanced computer hardware system for designing and software system for machining. The company is able to take on the international high level standards for accuracy and complexity

for the design and manufacturing of various types of bottle cap mould. We are committed professionally in these areas of specialisation for our business partners. Henceforth, we shall be dedicated to be a “One Stop Service Provider” for the services and product ranging from design, injection, manufacturing, assembly and after sales.

Ming San Feng Mould Co., Ltd upholds the principle of “Using science and technology as the driving force, building of core competitiveness and leader for the industry pioneers”. We shall continue to strive together with our business partner on the basis of equality, mutual benefit, and sincere co-operation. We have a saying that is “Only by being an honest person and diligent in working, can he build a brand with value”. The people of Ming San Feng Mould Co., Ltd is based in Shunde with a global view to expand its business horizon for this industry. We look forward to be your long term strategic partner.

—— 您的需求是我们的追求，提供优质配套服务！ ——
Your demand is our pursuit, we provide quality support service.





Trustworthiness Cooperation

需要以诚信为本建立良好的信誉，要与顾客有良好的沟通方便交易。
Need-based integrity, a good reputation to have good communication with customers convenient transactions.

本公司恪守“诚信合作”的理念，竭诚为顾客服务。

Our company insist on the principle of "trustworthiness cooperation" and service for every customers with all sincerity.



Company Culture

企业精神：真诚、拼搏、创新、进取、卓越
Company Spirit: Sincere, Diligent, Creative, Progressive, Excellent

企业理念：以可以为动力,打造核心竞争力,引领行业先锋!

Company Philosophy: Using science and technology as driving force, building core competitiveness and leader for industry pioneer!





用最好的品质服务于著名品牌

Serve the well-known brands with the best quality

铭三锋有限公司专业、专注瓶盖模具，与多家著名品牌建立长期直接或间接的战略合作关系。
Ming San Feng Mould Co., Ltd focuses on cap mold development. It has built direct or indirect long-term strategic partnership with a number of famous brands.



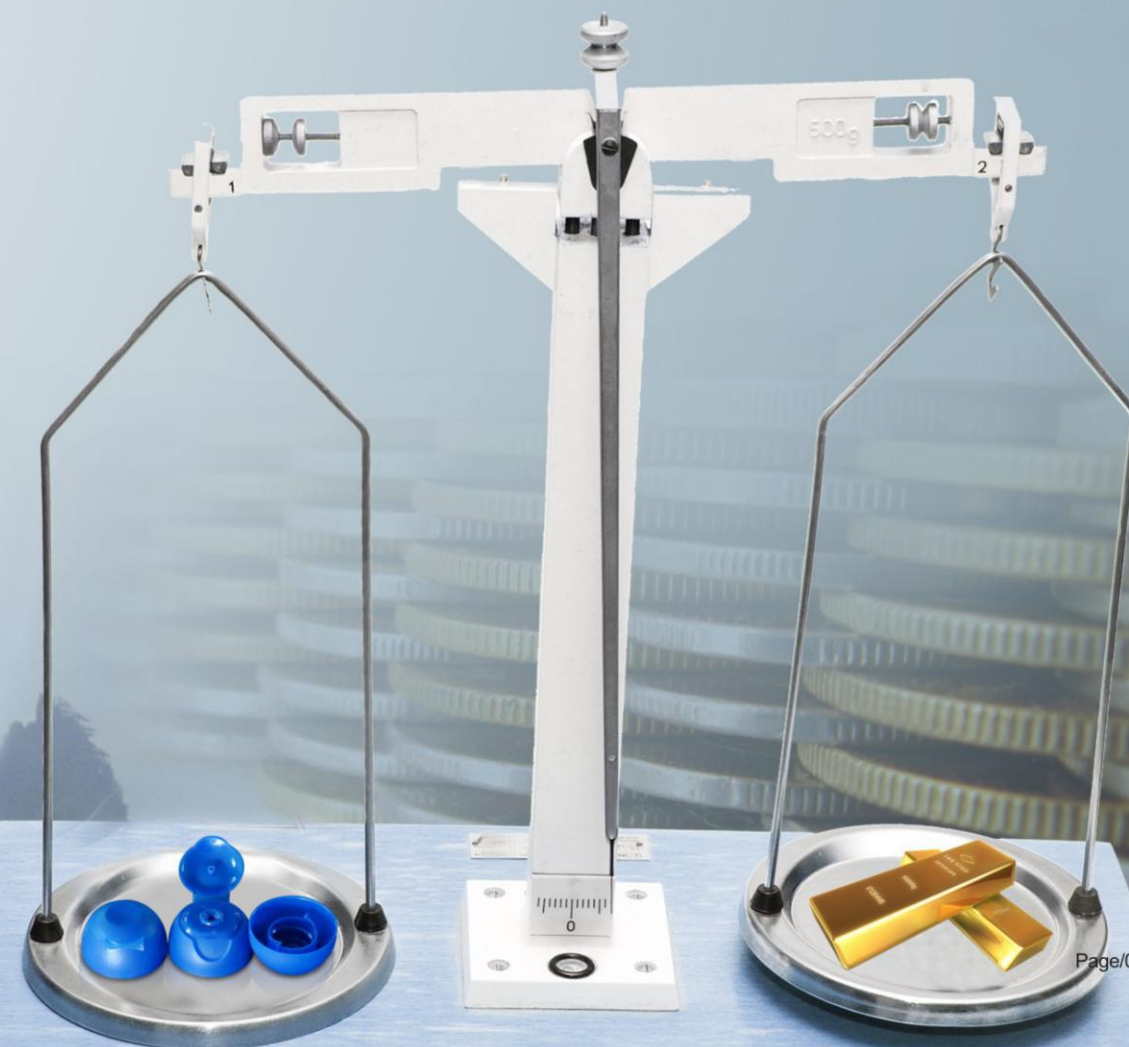
技术 引领行业先锋
Lead industry pioneer with professional Technology

品质 铸造品牌价值
Create brand value with top Quality.

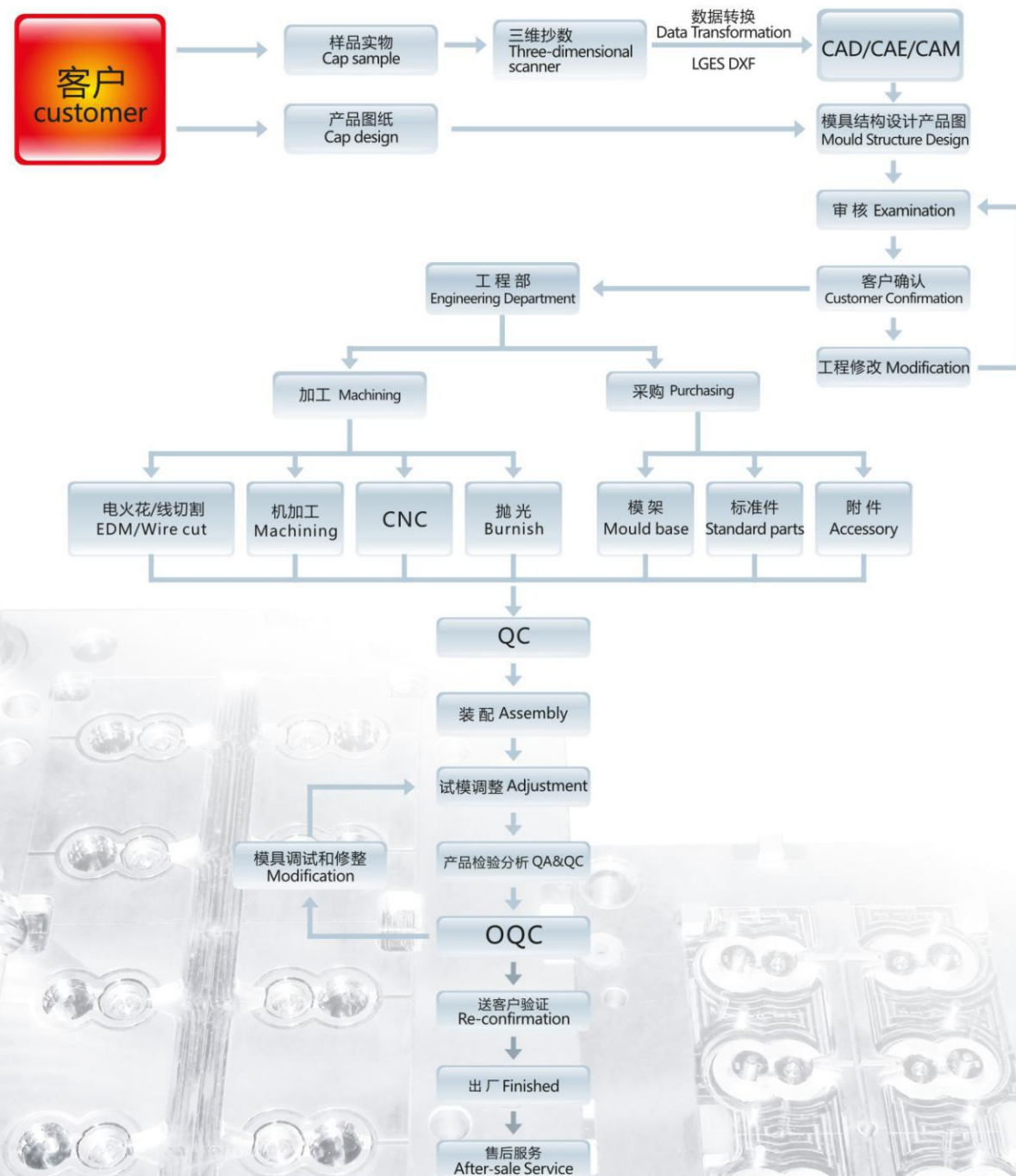
服务 成就企业未来
Achieve enterprise's future with good Service.

品质一是获得信任的砝码

品质是竞争致胜的关键，是永不止步的追求，是价值的另一个至高点。
Quality is key to gain trusts and win the competition
Quality is a never-ending pursuit, a supreme value.



模具制作流程 Molding Process

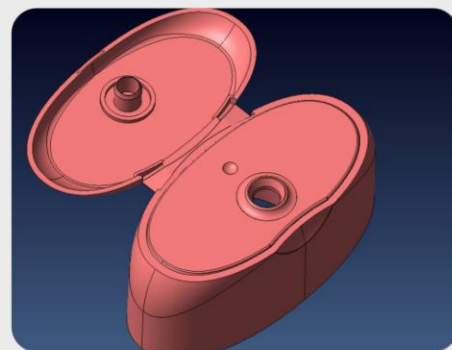


生产设备 Production Equipment

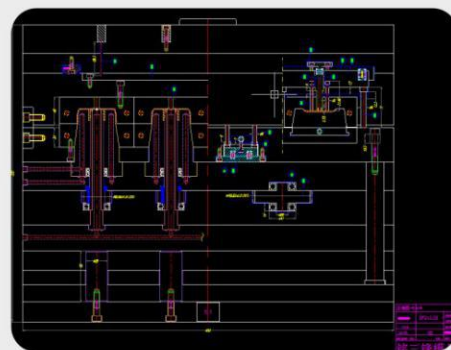


铭三锋模具以精立业，以质取胜的理念，满足客户最大的需求，公司现有加工中心，数控设备和专业化模具设计团队。

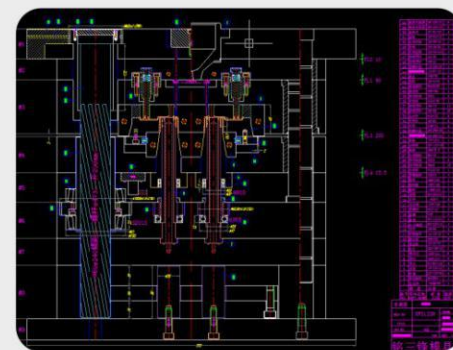
Ming San Feng Mould Co., Ltd provides quality product and service with the belief winning by good quality. Our company possesses advanced machining center, CNC equipment and professional cap mould design team.



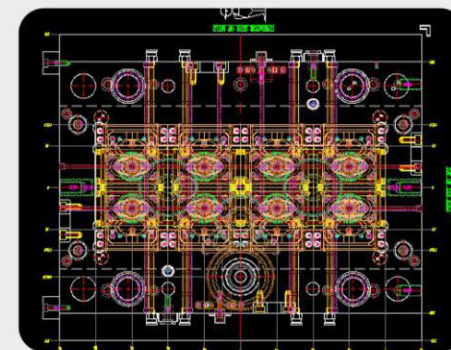
3D研发图 3D design



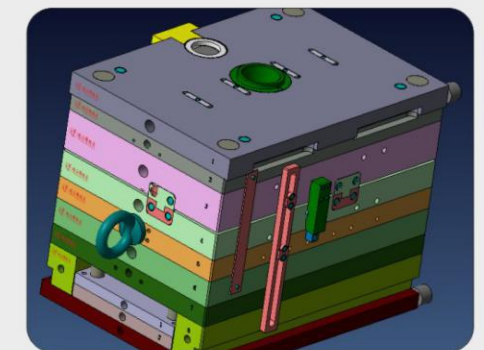
2D设计图 2D design



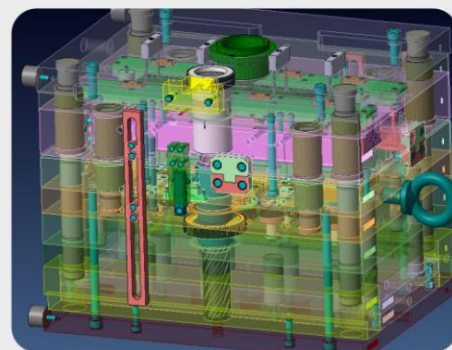
2D设计图 2D design



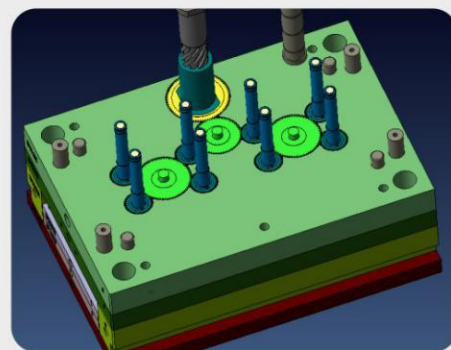
2D设计图 2D design



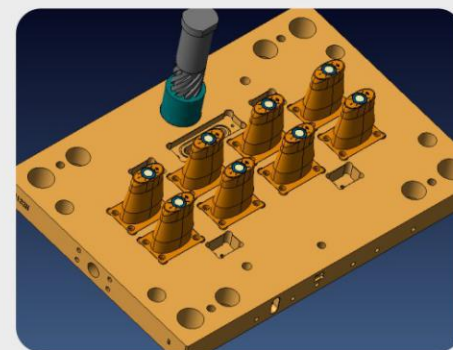
结构图 structured Chart



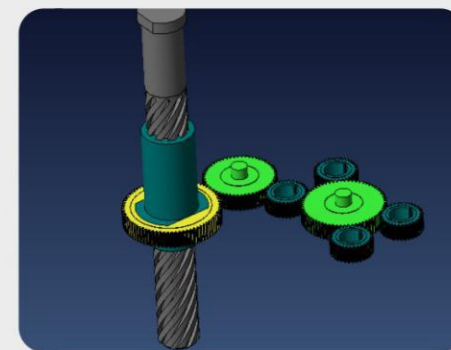
3D透视图 3D perspective Chart



后模 Core



后模 Core



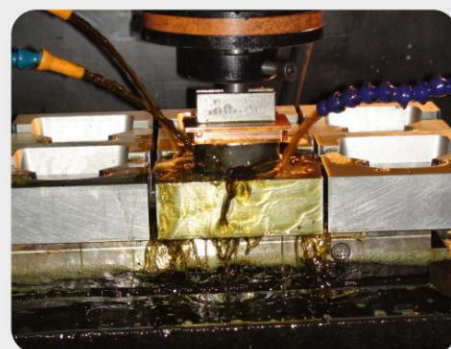
牙芯 Rotate Core



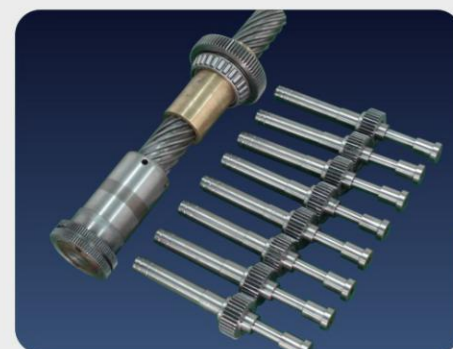
电极 Electrode



CNC加工 CNC Machining



EDM



来复线.牙芯 Rotate System.Core



芯 Core



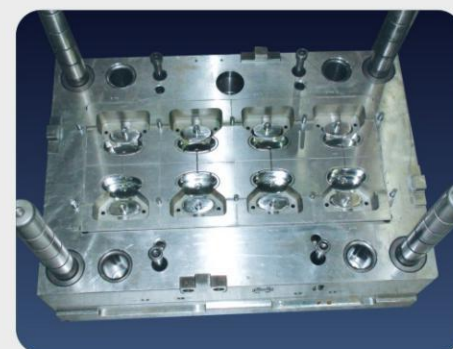
前腔 Front Cavity



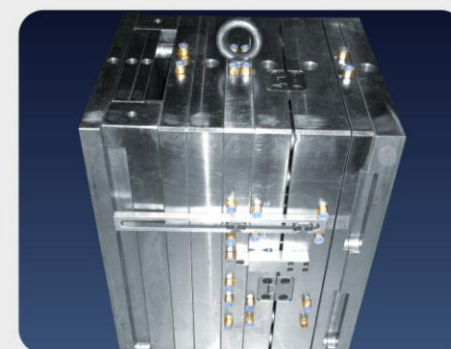
前腔 Front Cavity



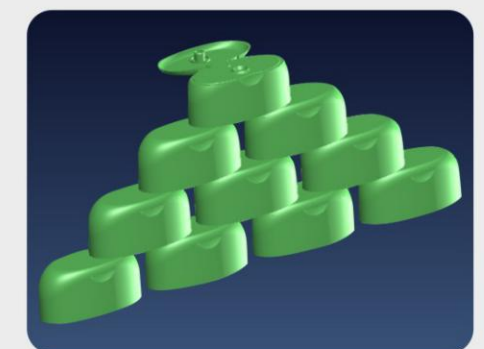
后模 Core



前模 Front Cavity

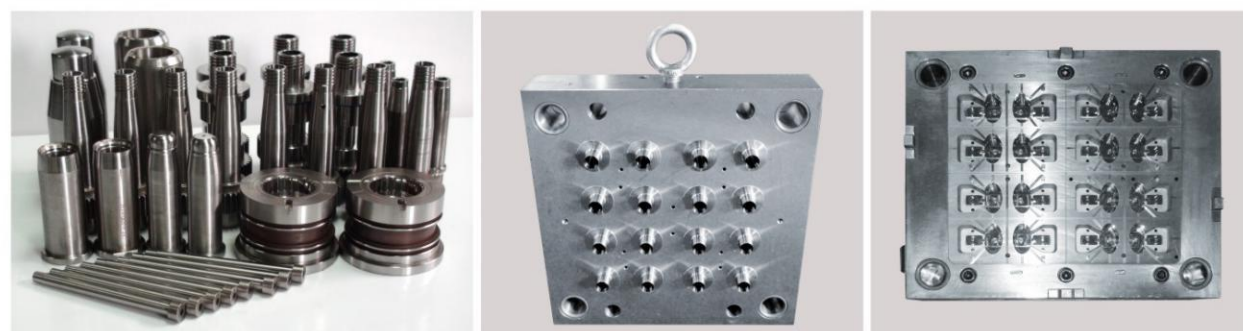


成品模 Finished Mould

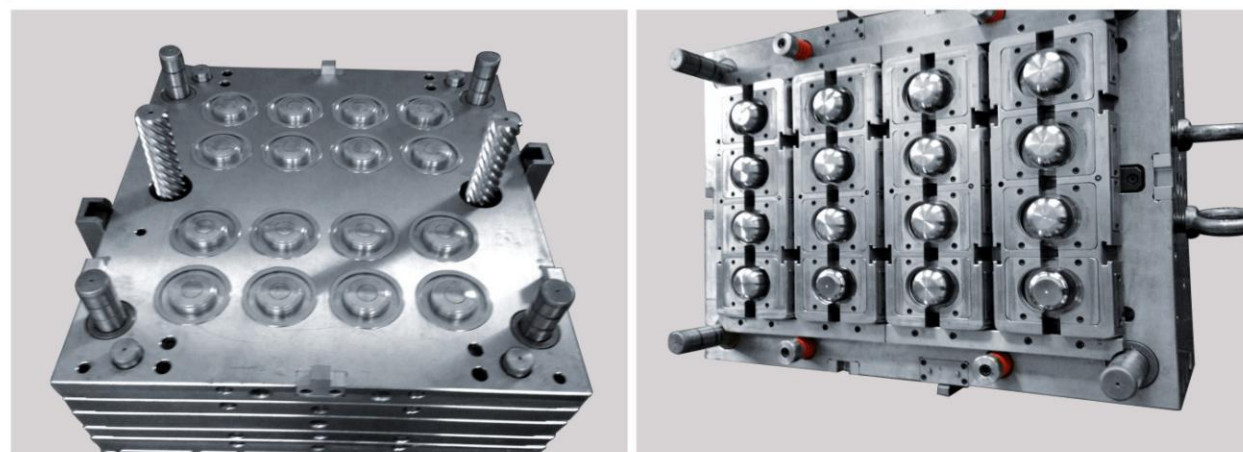


成品 Finished Cap

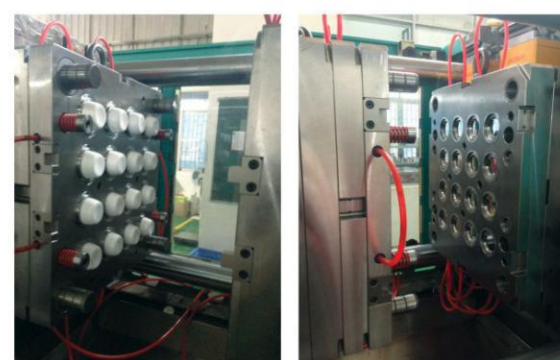
16腔旋牙模具 16Cavities Unscrew Mould



滋润霜系列模具 Emollient Cream Series Mould



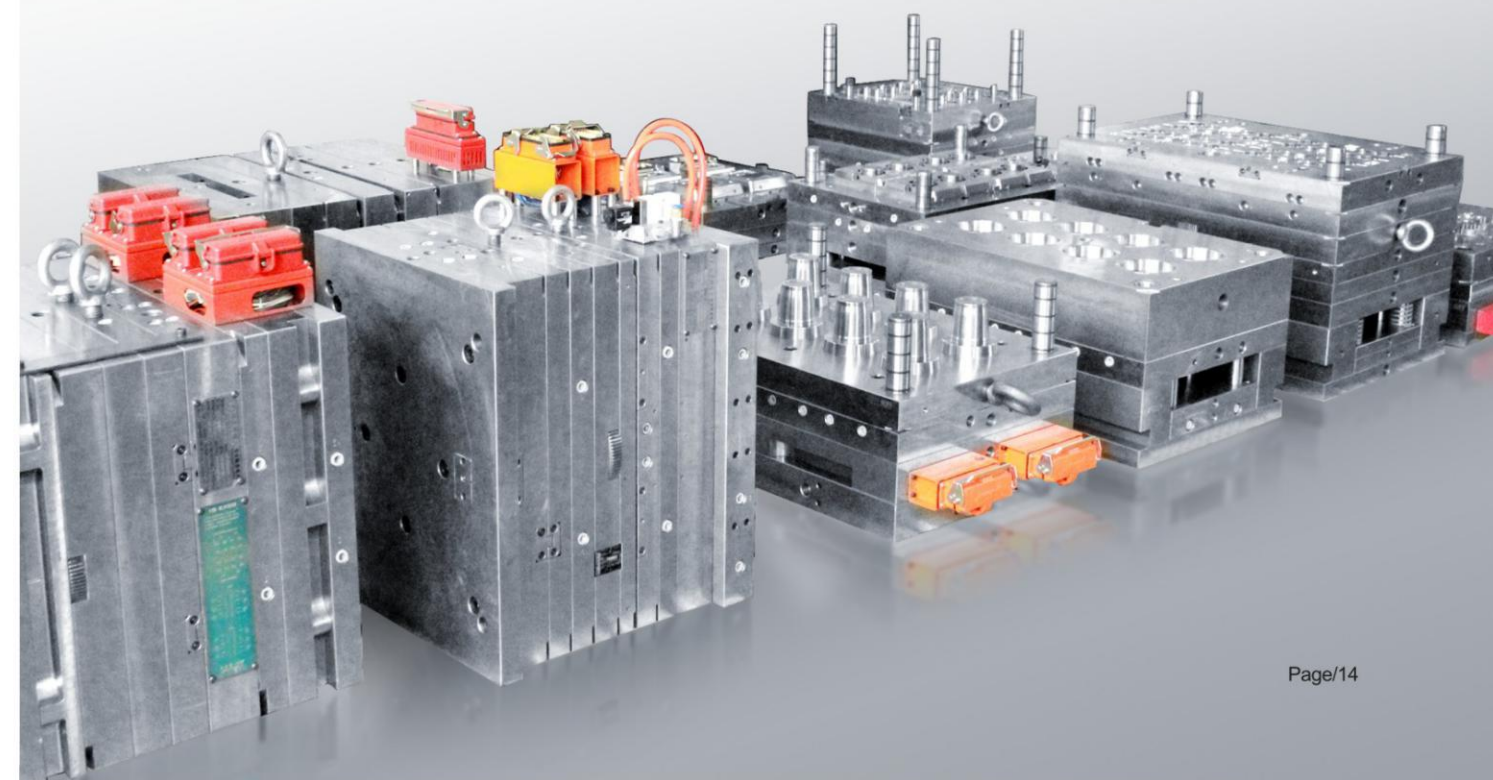
成型脱模 Injection Process



成品模 Finished Mould



Customer-oriented, promote innovation
以客为本，推动创新

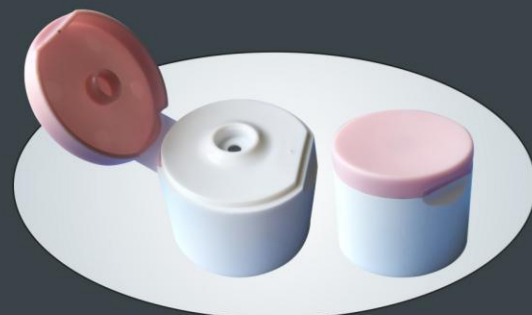


双色翻盖模具

M28-410翻盖模内盒盖模具(8腔)

In Mould Closing(IMC)Injection

M28-410 Flip Top Cap Moulding(8 Cavities)



产品重量：4g

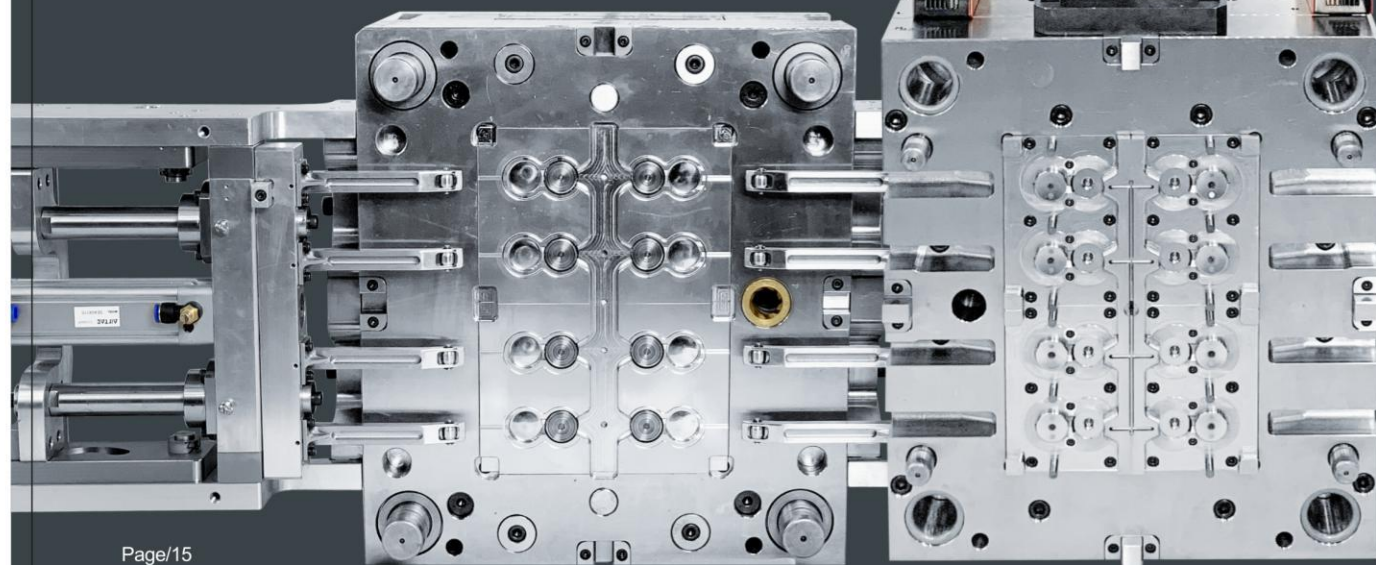
Cap weigh: 4g

成型周期：20秒

Cycle time : 20s

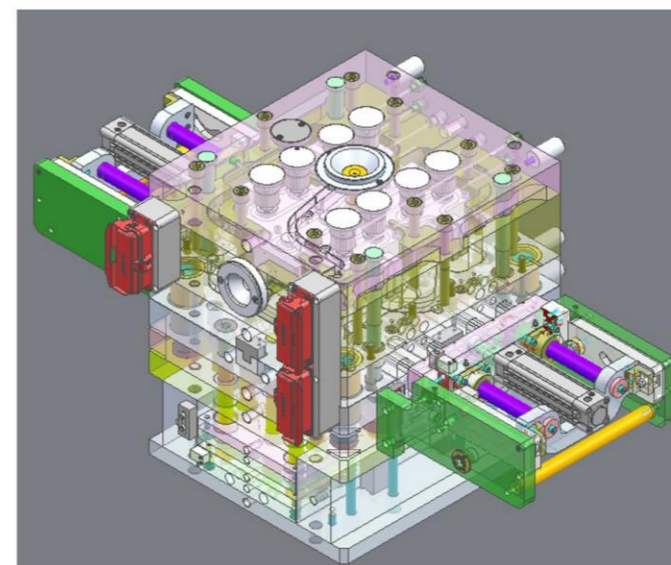
技术概括：热流道，旋牙，双色注塑，模内盒盖

Technology key words : hot runner, unscrewing, two-color, IMC



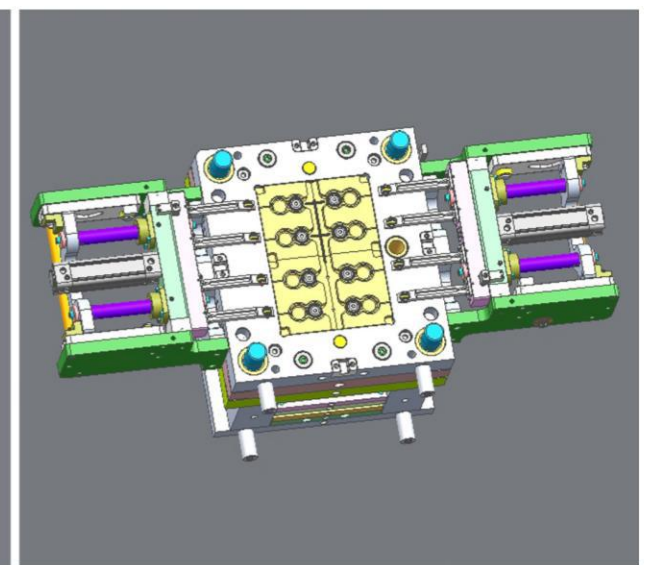
双色盖系列

Two-Color Cap Mould Series



双色M28-410翻盖模内盒盖模具(8腔)三维图

M28-410 Flip Top Cap In Mould Closing Moulding(8 Cavities)



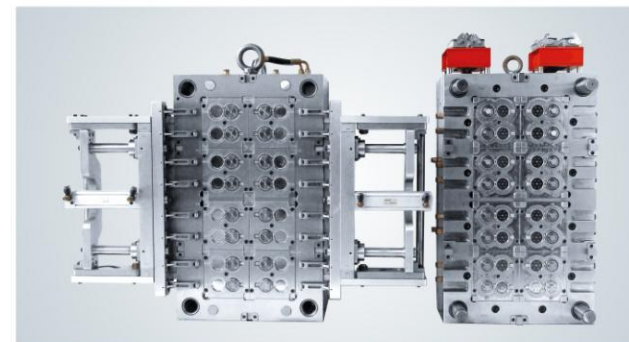
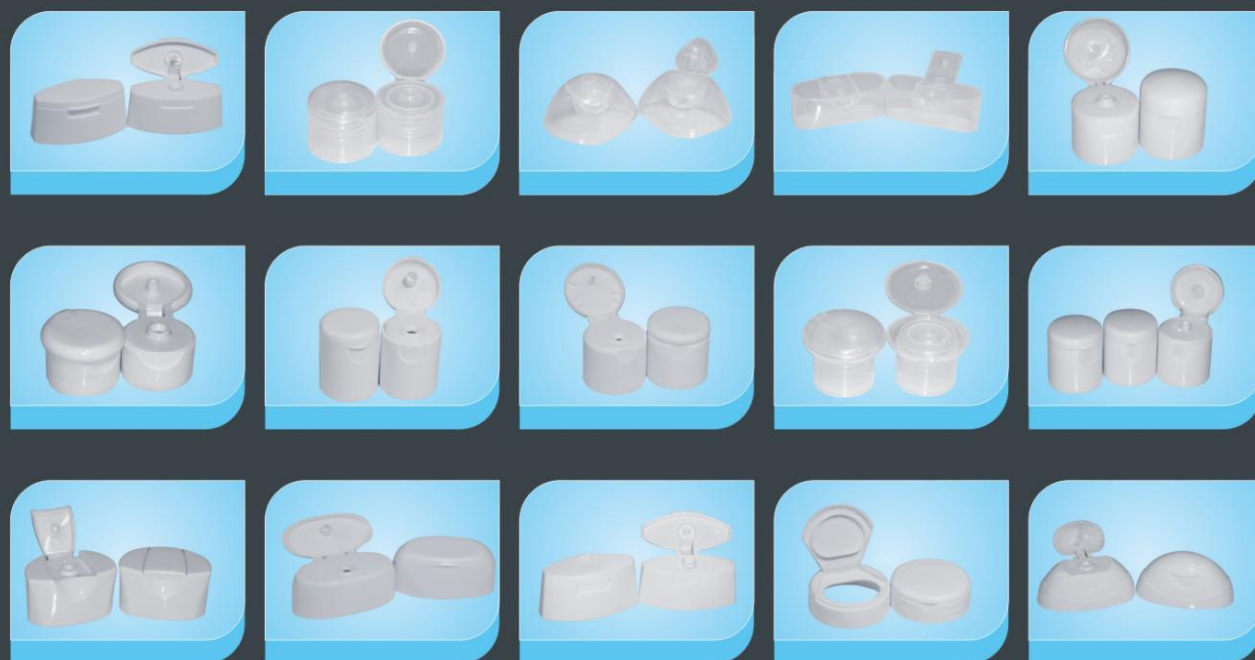
高品质产品源于自动化科技

High quality product comes from technology for automation

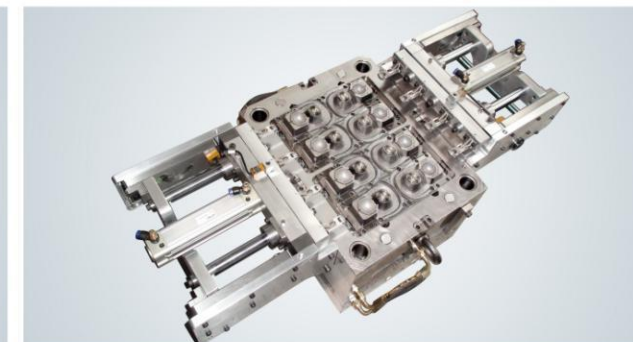
热流道多腔自动模内盒盖模具(IMC) Hot Runner Multiple-Cavity In Mould Closing(IMC) Injection Mould

我们的专业团队 为您提供一条龙服务
Professional team provides the one-stop service for you

- ◎生产线设计配套
- ◎自动模内合盖模
- ◎热冷道流盖模具
- ◎全自动合盖机械
- ◎注塑瓶盖
- ◎Production line design supporting
- ◎In Mould Closing(IMC) injection cap mould
- ◎Hot runner and cold runner injection cap mould
- ◎Automatic capping machine
- ◎Injection cap product



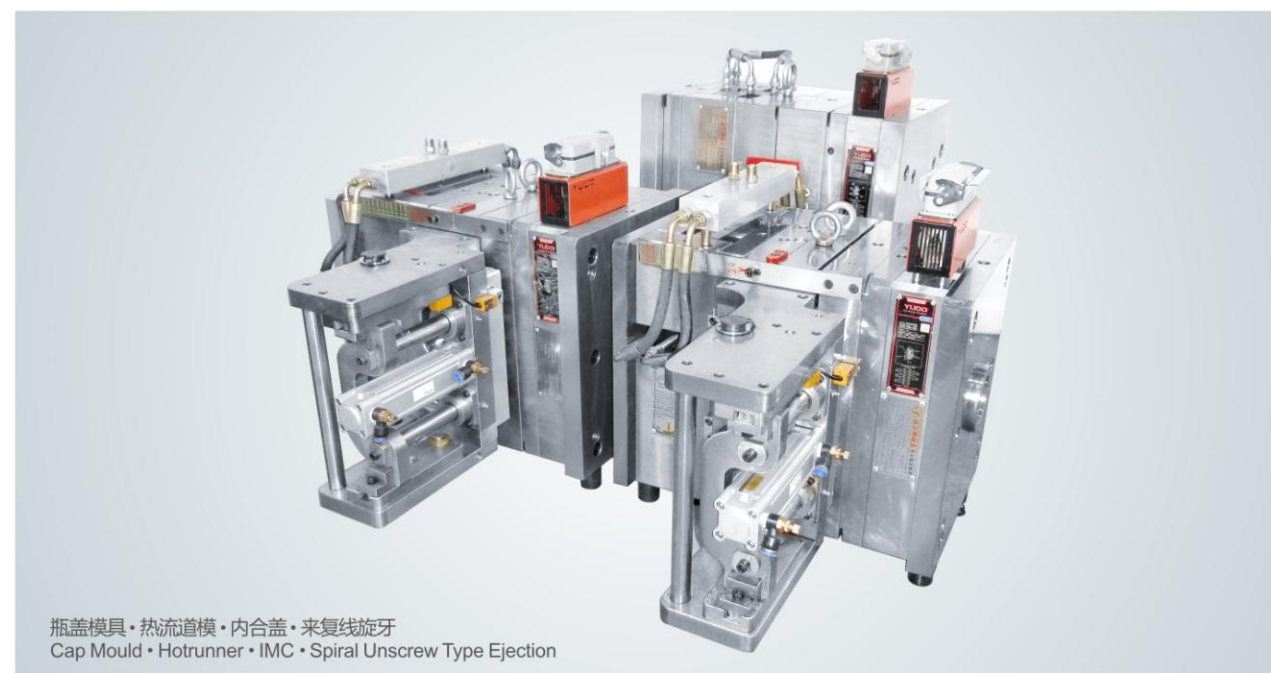
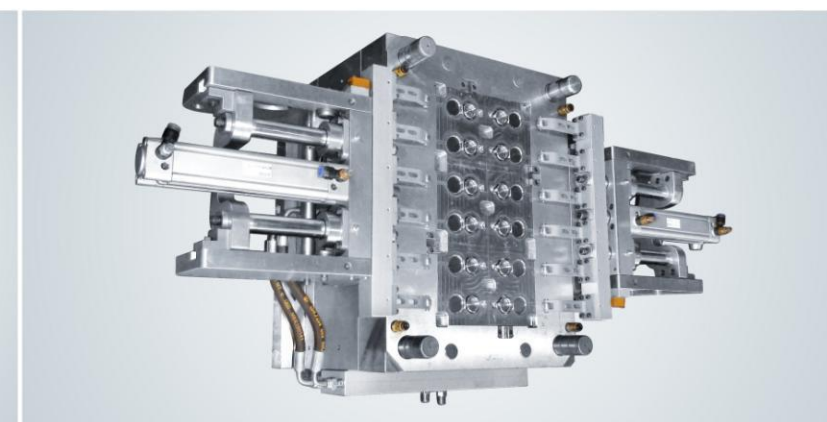
16腔爽身粉翻盖强脱模内合盖模具
16 CAV-Powder Flip Top cap Push-out IMC Mould



8腔洗发水翻盖强脱模内合盖模具
8CAV-Shampoo Flip Top cap Push-out IMC Mould



12腔翻盖模内合模具及样品
12 Cavities flip top cap in mould closing mould and sample



瓶盖模具·热流道模·内合盖·来复线旋牙
Cap Mould • Hotrunner • IMC • Spiral Unscrew Type Ejection

瓶盖注塑: Cap Injection



铭三锋有限公司专业、专注瓶盖模具，为世界各大品牌供应商加工制造模具:螺纹瓶盖旋盖模具，瓶用掀盖翻盖模具，软管螺纹盖模具，软管翻盖模具，医用瓶盖模具，防盗式瓶盖模具，通用塑料盖模具，扣位翻盖模具，特殊瓶盖模具，膏霜瓶面霜樽模具，化妆盒化妆镜模具，热流道瓶盖螺纹盖模具，吹瓶吹塑料中空成形模具，各种特别瓶盖、螺纹盖、旋盖模具。

Ming San Feng Co., Ltd. focuses on developing and manufacturing cap mold for the world's famous major brand suppliers. The products include screw cap mold, bottle flip top cap mold, tube screw cap mould, tube flip top cap mould, pharmacy bottle cap mould, anti-theft-type cap mold, plastic cap mold, button flip top cap mold, special cap mold, cream bottle mold, cosmetic mirror mold, hot runner screw cap mold, plastic hollow blowing forming mold and a variety of special and screw cap mould.



旋牙翻盖 Flip Top Cap



旋牙翻盖 Flip Top Cap



旋牙翻盖 Flip Top Cap



双色双孔扣牙翻盖
Jaw Type Flip Top Cap with Double-color and Double-cap



扣牙翻盖 Jaw Type Flip Top Cap



软管翻盖 Tube Flip Top Cap



软管翻盖 Tube Flip Top Cap



千秋盖 Disc Top Cap



千秋盖 Disc Top Cap



润滑油盖 Lubricating Oil Cap



润滑油盖 Lubricating Oil Cap



润滑油盖 Lubricating Oil Cap



洗衣液盖 Laundry Liquid Bottle Cap



洗衣液盖 Laundry Liquid Bottle Cap



酱油拉盖 Cruet Raghet



食用油盖 Edible Oil Bottle Cap



普通旋盖 Screw Cover Cap



普通旋盖 Screw Cover Cap



药用盖 Pharmacy Bottle Cap



药用盖 Pharmacy Bottle Cap



口香糖盖 Gum Tin Cap



口香糖盖 Gum Tin Cap



PMMA



过滤器 Strainer

注塑成型中不良现象解决方法 The Solution of Injection Badness Phenomenon

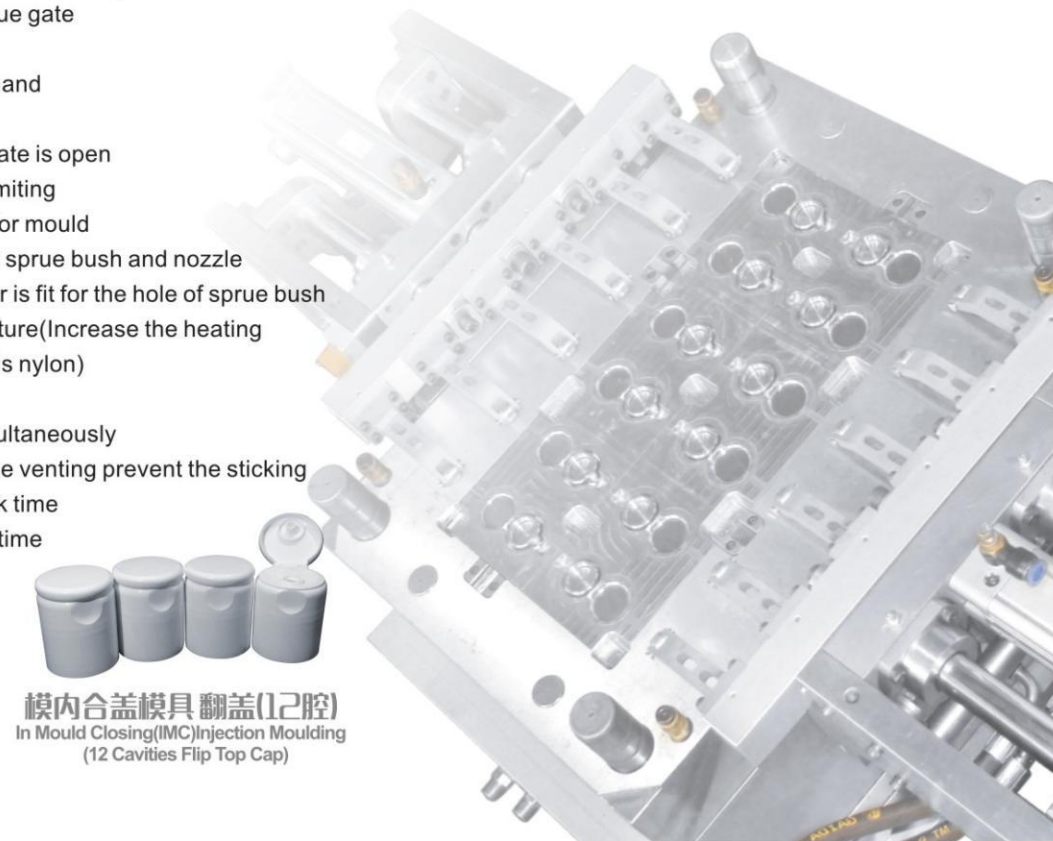
注塑成型中不良现象解决方法 The Solution of Injection Badness Phenomenon

对策 Solution:

1. Increase the injection pressure
2. Reduce the injection pressure
3. Raise the barrel's temperature
4. Reduce the gun barrel's temperature
5. Increase the holding and extend the holding time
6. Reduce the holding and shorten the holding time
7. Increase nozzle's temperature
8. Clean the nozzle's hole
9. Affirm the nozzle's compactness
10. Increase the screw turning speed
11. Reduce the screw turning speed
12. Fasten the nozzle
13. Choose the right nozzle
14. Increase the clamping force
15. Reduce holding pressure
16. Reduce the injection speed
17. Increase the injection speed
18. Increase the backpressure
19. Reduce the backpressure
20. Use a bigger aperture open type nozzle
21. Increase the mould's temperature
22. Reduce the mould's temperature
23. Grinding mould or changing the pliable angle
24. Make sure the mould is correct
25. Grinding the nozzle, runner or sprue gate
26. Enlarge the nozzle and sprue gate
27. Setting the mould venting
28. Drying the material beforehand
29. Affirm the material is clean
30. Hopper is full or hopper's gate is open
31. Adjust the injection route limiting
32. Set the cold material level for mould
33. Adjust the contact between sprue bush and nozzle
34. Affirm the nozzle's diameter is fit for the hole of sprue bush
35. Lower the heating temperature(Increase the heating temperature if the material is nylon)
36. Affirm no block in material
37. Adjust to fill all cavities simultaneously
38. Check the mould and set the venting prevent the sticking
39. Lengthen cooling and break time
40. Shorten cooling and break time

现象 Phenomenon:

1. Material escape from the nozzle and sprue bush
2. Short shots
3. Screw stand fast
4. Shrink mark
5. Burn mark
6. Shading on the surface
7. Flashing
8. Blemish on surface
9. Crazing
10. Unseparated
11. The sprue bush gate is broken
12. Warping
13. Welding line
14. Fragile/Fragmentation
15. Flow line
16. Cold slag
17. Whitening/White mark
18. Spot/Surface inhomogeneity
19. Bubble/Air Holes
20. Spiral grain



模内合盖模具翻盖(12腔)
In Mould Closing(IMC)Injection Moulding
(12 Cavities Flip Top Cap)

现象 Phenomenon	1 喷嘴 和 唧咀 接触 处 漏料	2 充填 不足	3 螺杆 不后 退	4 缩水 凹痕	5 烧焦	6 表面 有阴 影	7 毛边	8 表面 污	9 银纹	10 离型 不良	11 唧咀 水口 断	12 变形 弯曲	13 溶接 线	14 脆弱 碎裂	15 波浪 痕皱 纹	16 冷料 渣	17 白化 白痕	18 斑点 表面 不均	19 气泡 空洞	20 漩涡 纹
对策 Solution																				
1.射出压力加大		●		●				●				●	●		●				●	
2.射出压力降低					●		●			●	●	●					●			
3.炮筒温度升高		●	●	●		●		●				●	●	●	●	●	●	●		●
4.炮筒温度降低			●	●	●		●			●		●		●					●	
5.加大保压及延长保压时间		●		●				●					●		●				●	●
6.减少保压及缩短保压时间							●			●	●	●		●						
7.射嘴温度升高		●		●		●		●					●		●	●		●		●
8.射嘴孔变小、堵塞		●																		
9.确认射咀紧密度	●	●		●																
10.螺杆回转速度加大			●																	
11.螺杆回转速度减小			●	●	●	●		●	●				●	●	●		●	●	●	●
12.射嘴松脱		●																		
13.喷嘴选择不当	●	●		●	●			●								●		●		●
14.锁模力加大							●													
15.保压降低							●			●		●					●			
16.射出速度降低		●		●	●	●	●	●	●	●		●	●	●			●	●	●	●
17.射出速度升高		●		●	●	●		●				●	●	●	●		●	●		
18.背压加大		●		●	●	●		●	●			●	●	●	●	●	●	●	●	●
19.背压降低			●		●															
20.用孔径较大的开放形喷嘴		●		●	●			●	●			●	●		●				●	
21.模具温度升高		●		●		●		●	●	●		●	●	●	●	●	●	●	●	●
22.模具温度降低				●			●	●		●	●	●		●					●	
23.研磨模具及锐角改圆滑						●		●		●							●			
24.确认模具是否正确		●		●	●	●	●	●	●	●	●		●				●			●
25.研磨唧咀孔、流道及浇口						●		●		●	●									
26.扩大唧咀孔及浇口	●	●		●	●	●		●	●			●	●	●	●	●	●		●	●
27.设定模具排气		●			●	●		●	●				●							
28.原材料要进行预备干燥			●		●	●		●	●				●	●		●	●	●		
29.原材料不干净						●		●	●					●						
30.料口空了或料斗关闭			●		●															
31.计量用行程限位设定不合理		●		●			●													
32.模具设置冷料位		●		●	●	●		●				●	●	●	●	●	●		●	●
33.调整射咀及唧咀接触面	●	●						●			●						●			
34.确认射咀直径配合唧咀孔	●								●	●	●					●		●		
35.降低发热温度(如果使用的是尼龙要升高温度)			●																	
36.材料内形成堵塞		●	●					●												
37.为了使多个型腔同时充满		●		●		●									●					
38.检查模具, 设定排气										●										
39.冷却和中间时间加长				●						●	●	●							●	
40.冷却和中间时间缩短					●															